

Work Order ID 84369-2

May-10-12 2:34:59 PM

84369

Page 1

Item ID: D4062-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Tank Support

Start Date: 10/05/2012 Start Qty: 4.00

4

Required Date: 24/05/2012 Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4062	C								

100

100

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D4062-1 BLANK ✓

UHMW 1" Blk

4 0 JM
12-6-6

102

102

3.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

12-6-7

1 4

105

105

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA949

DWG REV: 2

FOLIO REV: 10/11

12-6-7

1 4

12-6-7

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Item ID: D4062-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Tank Support

Start Date: 10/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
106 *106* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		24 12-C-7 A 12-6-7		1 d			
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		Da 12/06/07		1	d		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>111A</u> Memo	0.00 0.00				1	d		12-06-07

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Item ID: D4062-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Tank Support

Start Date: 10/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/6/11 *[Signature]*

MSF
12-06-08

Picklist Print

May-10-12 2:35:02 PM

Page 1

Work Order ID: 84369

84369

Parent Item: D4062-1

D4062-1

Parent Item Name: Upper Tank Support

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV:A NEW ISSUE 10-06-22 JLM VERIFIED BY:DD
 REV:B AS PER REV B 11-11-23 JLM VERIFIED BY:DD
 AS PER REV C 12-03-08 JLM VERIFIED BY:DD
 IPP
 IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

53.2100

14.4

MUHMWB10

**

B12-6-5

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

30.1

120972

3

121346

27.1

MAT019

1.5

118814

1.5

ST052

21.60999474

121277

12.8

121278

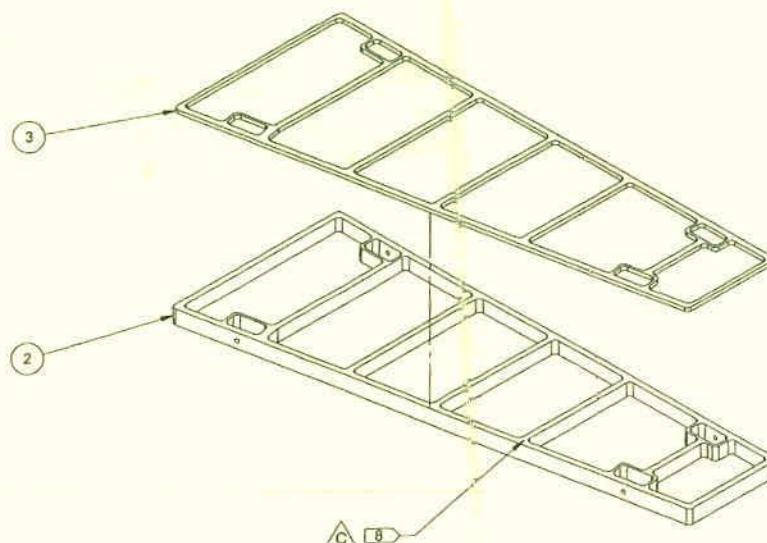
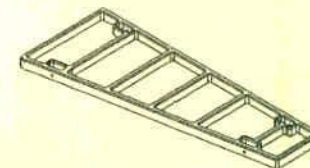
8.80999474

121954

121954

JM
12-6-6

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4062-041	TANK SUPPORT ASSEMBLY
2	1	D4062-1	LOWER TANK SUPPORT
3	1	D4062-3	UPPER TANK SUPPORT



D4062-041 TANK SUPPORT ASSEMBLY

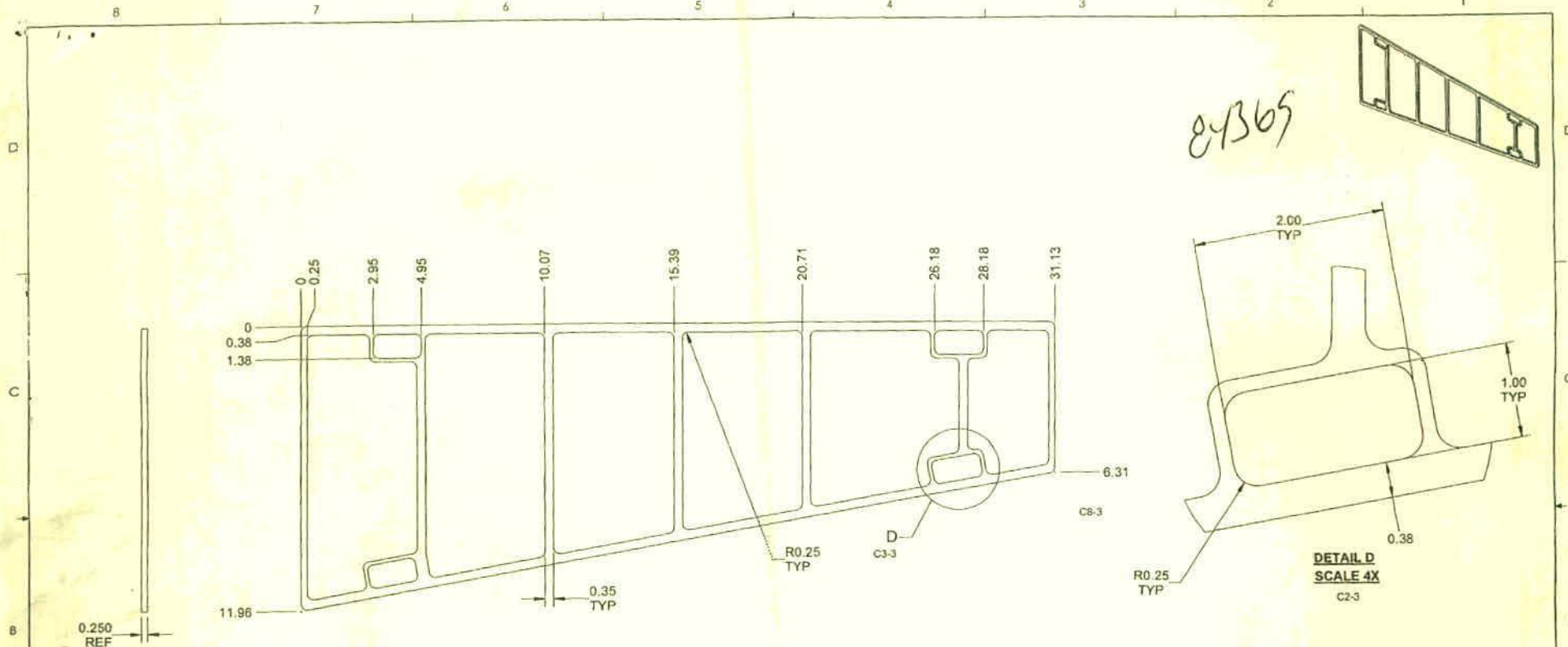
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.91 lbs
- 8) BOND ITEMS 2 & 3 TOGETHER USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84368 MLJ
12/05/10

2012-03-02

C	REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE C-BORE.	DC	11.12.14
B	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4062	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		TANK SUPPORT	NTS
DATE	11.12.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY REASON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4062-3 UPPER TANK SUPPORT

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 0.25 THICK
REF DART SPEC MUHMWB025
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs
- 8) CUT PER D4062-3.DXF

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4062	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		TANK SUPPORT	NTS
DATE	11.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DRAWING IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED OR COPIED OR COMMUNICATED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 84369
Description: LOWER TANK SUPPORT		Part Number: 24062-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	+/- .030	.50	✓		RA26	Seen
3.94	+/- .030	3.94	✓		✓	
23.36	+/- .030	23.36	✓		RA01	TAP5
.257	+/- .006	.257	✓		RA26	Seen
1.00 ref	+/- .030	1.006	✓			
.13	+/- .030	.135	✓			
.38	+/- .030	.375	✓			
.38	+/- .030	.374	✓			
3.07	+/- .030	3.07	✓			
26.30	+/- .030	26.30	✓			
.50	+/- .030	.50	✓		RA26	Seen
4.02	+/- .030	4.02	✓		RA26	Seen
23.89	+/- .030	23.89	✓		RA01	TAP5
2.00	+/- .030	1.998	✓			
.38	+/- .030	.360	✓			
1.00	+/- .030	1.002	✓			
.35	+/- .030	.355	✓			

Measured by: RG/AD
Date: 12-6-7

Audited by: B.A
Date: 12/08/07

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

